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647.0112

Job Sheet 202744



Part No: 647.0112

Job Qty: 10 pcs

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/13/19

Description:

Type: Stock

Note: DWG 647.0100 REV.B SHEET 3 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS IPP REV:B 18.02.08 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		12/13/19	0.17	0.33	Waterjet - Flow		2/19/11/08
110	QC 2	10 pcs		12/13/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2/19/11/08
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	10 pcs	12/13/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	NOV 13 2019
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	10 pcs	12/13/19	0.25 0.50	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	NOV 18 2019
140 QC 5	10 pcs	12/13/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	NOV 20 2019
				QC 5 - 61	9-89
				QC 5 - 81	
150 Spray Paint - 2 - B4B	10 pcs	12/13/19	0.00 0.23	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	RD 19-11-20
				Spray Paint - 3 - B4B	

160 QC 14	10 pcs	12/13/19	0.00 0.00	Spray Paint - 4 - B4B	
				QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	DAS NOV 29 2019 40 9-89
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
QC 14 - 81					
170 Packaging 3-1 - Stock - B4B	10 pcs	12/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS 28 9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	12/13/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	3-89
Part Op 100 - 1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary					DEC 02 2019
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)					
120 - (QC8- Inspect parts - second check)					
130 - (Form as per dwg) USE DT9834 FOR FORMING					
140 - (QC5- Inspect part completeness to step on W/O)					

150 - (Spray Paint / NDT Room) PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N PRIME AS PER DWG NOTE 6
 BATCH: 5195221
 160 - (QC14- Inspect Spray Paint)
 170 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	.3250 sf (.0325 ea)	100-Waterjet - Flow - 1	<u>5155921</u> <u>5216339</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S14GA	0	42	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176		
2	Strut Bracket	0.191Inches + 0.005 - 0.001	0.196 0.190		
3	Strut Bracket	0.300Inches ± 0.030	0.330 0.270		
4	Strut Bracket	0.900Inches ± 0.030	0.930 0.870		
5	Strut Bracket	0.350Inches ± 0.010	0.360 0.340		
6	Strut Bracket	1.500Inches ± 0.030	1.530 1.470		
7	Strut Bracket	1.006Inches ± 0.030	1.036 0.976		
8	Strut Bracket	0.080Inches ± 0.010	0.090 0.070		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:							

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AEROSPACE

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Container No: S230329



Part: 647.0112

Job No: 202744

Serial No/Batch: S230329

Revision: 8

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/06/19